

**Work Order ID 55600**

January 22, 2010 3:03:23 PM

Page 1

Item ID: D119-696-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Dual Cargo Mirror Assy

Start Date: 1/22/10 Start Qty: 2.00

Required Date: 2/11/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *AL*Date: *10-1-22* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3074

A2 *✓* *0.049 wall*

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1- punch one side  
2- slide parts in tube  
3- punch other side  
4- bend as per dwg D3074  
5- drill holes as per dwg D3074  
6- deburr and polish

110

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control



QC

Quality Control

100

Small Fab

Small Fab

110



QC

Quality Control

Draw Nbr

Revision Nbr

D3074

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Quality Control



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Quality Control



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Quality Control

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Quality Control



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110



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QC

Memo

0.00

Quality Control



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110



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QC

Memo

0.00

Quality Control



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Quality Control

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Memo

0.00

Quality Control



QC

Quality Control

100

Small Fab

Small Fab

110



QC

Quality Control

Draw Nbr

Revision Nbr

D3074

A2 *✓* *0.049 wall*

0.00

100

Small Fab

Small

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55600**

January 22, 2010 3:03:23 PM

Page 2

Item ID: D119-696-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Dual Cargo Mirror Assy

Start Date: 1/22/10 Start Qty: 2.00

Required Date: 2/11/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



Small Fab

Small Fab

Memo

Small Fab

Assemble as per dwg D3074

0.00

0.00

=&gt; m-l 10/02/01

(4x)

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

=&gt; 5 10/02/01

(x4)

140



Packaging

Packaging

Identify as per dwg &amp; Stock Location:

PPP

Memo

55599

0.00

0.00

10/02/01 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 55600**

January 22, 2010 3:03:23 PM



Page 3

Item ID: D119-696-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Dual Cargo Mirror Assy

Start Date: 1/22/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/11/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/03 *[Signature]*

ME

16-02-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 22, 2010 3:03:28 PM

Page 1

Work Order ID: 55600



Parent Item: D119-696-043



Parent Item Name: Dual Cargo Mirror Assy

Start Date: 1/22/10

Required Date: 2/11/10

Comments: IPP Rev: A 08-02-19 New issue DD verified by: LL

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD10

Purchased No



WAS11491003635

M113368

Each 0.0000 12.0000

Washer

24x m-h 10/01/29 \*

D2011-101

Manufactured No



Each 39.0000 4.0000

6" Mirror

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

39

53992

39

Each 23.0000 4.0000

8x m-h 10/01/29 \*

D2054

Manufactured No



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST005

23

53179

23

Each 12.0000 4.0000

8x m-h 10/01/29 \*

D2055

Manufactured No



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST005

12

47562

12

8x m-h 10/01/29 \*

Clamp

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 2

January 22, 2010 3:03:28 PM

Work Order ID: 55600

Parent Item: D119-696-043

Parent Item Name: Dual Cargo Mirror Assy

Comments: IPP Rev:A 08-02-19 New issue DD verified by: LL

Start Date: 1/22/10

Required Date: 2/11/10

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2056

Manufactured

No

Each

2.0000

2.0000



Bell Crank

2x  
B55598 10-1-29  
SP  
\*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST006

2

51429 ✓

2

Each

13.0000

2.0000

D3072-1

Manufactured

No



Bracket

2x m-k 10/01/29  
\*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

37635 ✓

1

53119 ✓

12

Each

11.0000

2.0000

D3072-2

Manufactured

No



Bracket

1x m-k 10/01/29  
3x m-k 10/01/29  
\*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11

37636 ✓

1

53120 ✓

10

1x m-k 10/01/29  
3x m-k 10/01/29  
\*

January 22, 2010 3:03:28 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 22, 2010 3:03:28 PM

Work Order ID: 55600



Parent Item: D119-696-043



Parent Item Name: Dual Cargo Mirror Assy

Start Date: 1/22/10

Required Date: 2/11/10

Comments: IPP Rev:A 08-02-19 New issue DD verified by: LL

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M304TR0.500W.049

Purchased

No

f

86.5100

7.3474



304 RD Tube .500 x .049W

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

86.5099895

111814 ✓

86.5099895

Each

2,949.000

6.0000

MS21042L3

Purchased

No



Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

2949

110844

35

111274

27

111668

52

112314 ✓

337

112385

498

113523

300

113537

700

113644

1000

M-L \*

14.6948 10/01/29

12X M-L 10/01/29 \*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 4

January 22, 2010 3:03:28 PM

Work Order ID: 55600



Parent Item: D119-696-043



Parent Item Name: Dual Cargo Mirror Assy

Start Date: 1/22/10

Required Date: 2/11/10

Comments: IPP Rev:A 08-02-19 New issue DD verified by: LL

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-18		Purchased	No				Each	36.0000	6.0000			



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36

110916

36

10/01/29 \*

12x m-h

January 22, 2010 3:03:28 PM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

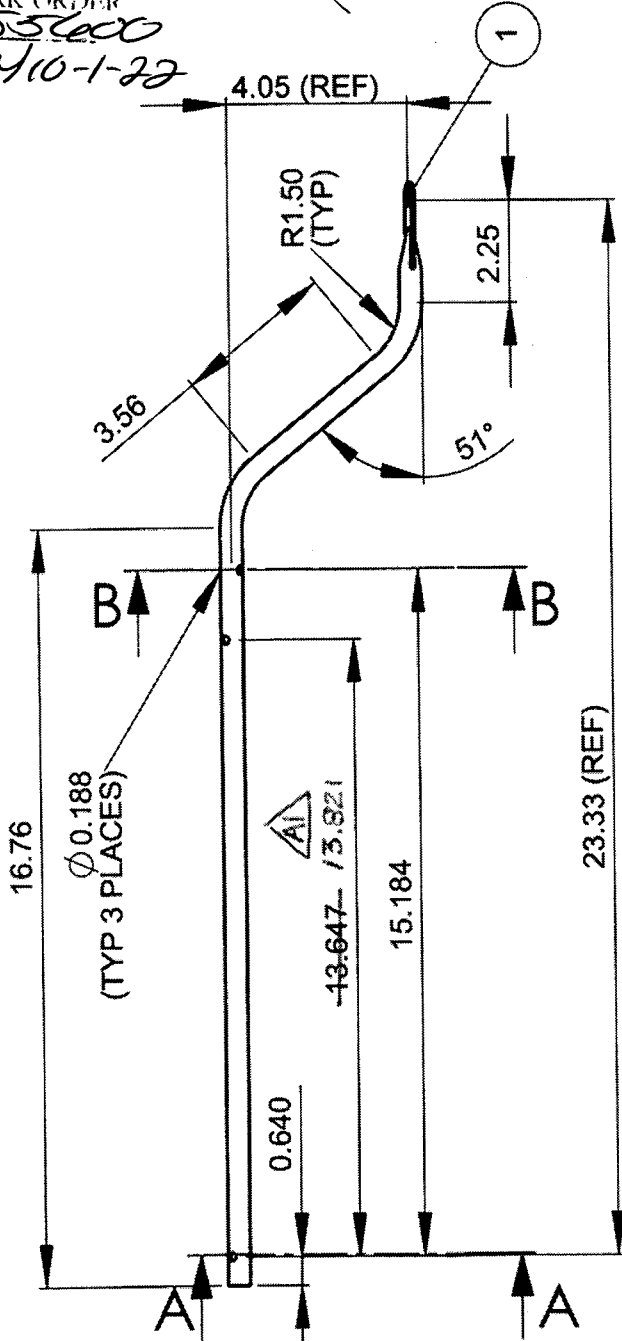
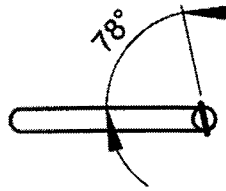
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3074	REV. A SHEET 1 OF 2
DATE 01.12.17		TITLE ARM	SCALE 1:4
A	01.12.17	NEW ISSUE	
A1	02.01.15	13.821 WAS 13.647 <i>CP</i>	
A2	02.03.22	ADD FINISH <i>CP</i>	

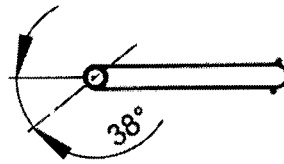
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *55600*  
*B10-1-22*



*UNDER REVIEW*  
*03.06.23*  
*CHANGE TO 0.049"*  
*WALL THICKNESS*

*Oil*  
*Ball oil*  
*10.0.25*

SECTION B-B  
(1 PLACE)



SECTION A-A  
(TYP 2 PLACES)



RELEASED  
*02.01.15*

- D3074-1**
- 1) PUNCH END PER SPEC CONTROL DRAWING D2727
  - 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE SEAMLESS TUBING IS USED
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES
  - 5) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 (A2)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

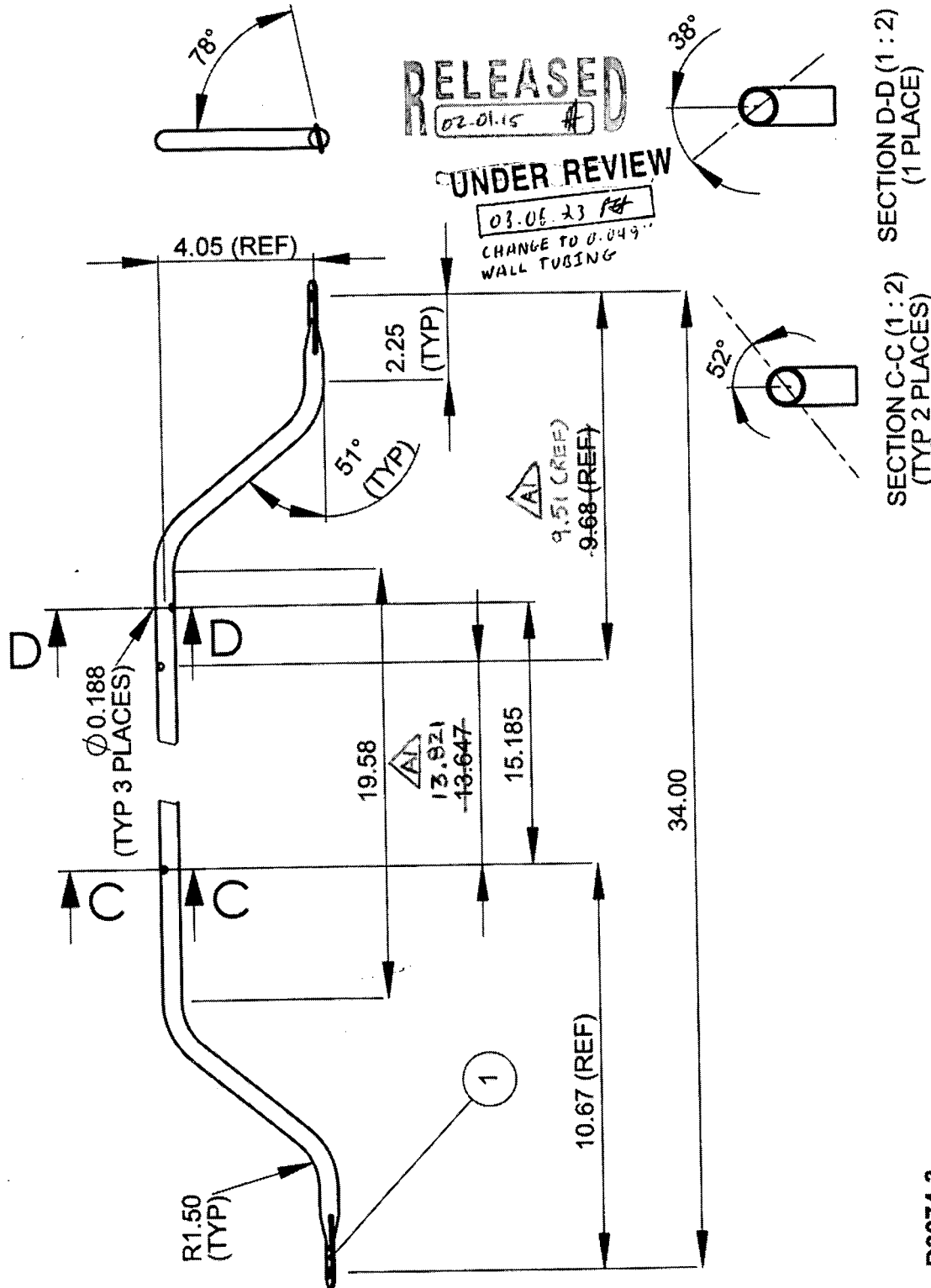
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3074	REV. A SHEET 2 OF 2
DATE 01.12.17	TITLE ARM		SCALE 1:4

**D3074-3**

- 1) PUNCH ENDS PER SPEC CONTROL DRAWING D2727
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\phi$  0.50 x 0.035 WALL  
ENSURE SEAMLESS TUBING IS USED
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS NOT SYMMETRIC

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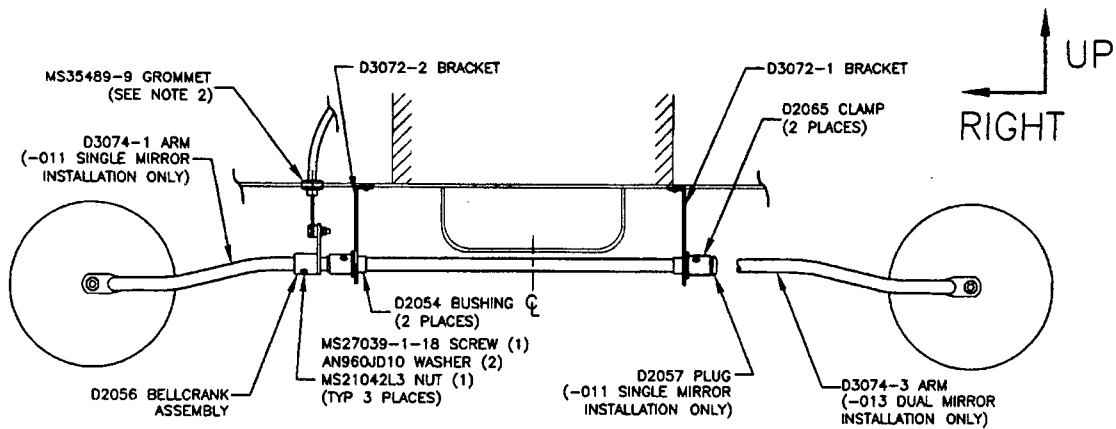
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

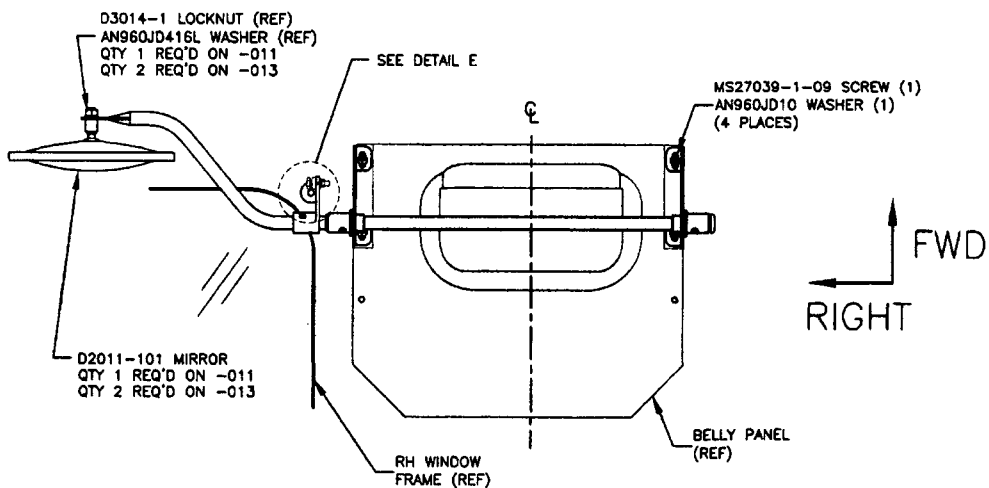
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Figure 25-2 – View A: Looking Aft**  
(D119-696-011/-013 Mirror Shown)



**Figure 25-3 – View B: Looking Up**  
(D119-696-011 Mirror Shown, -013 similar)

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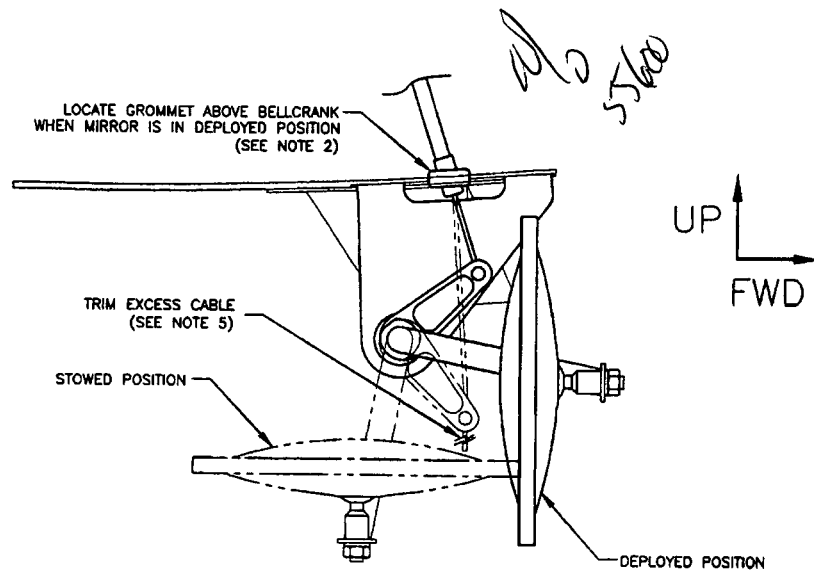
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

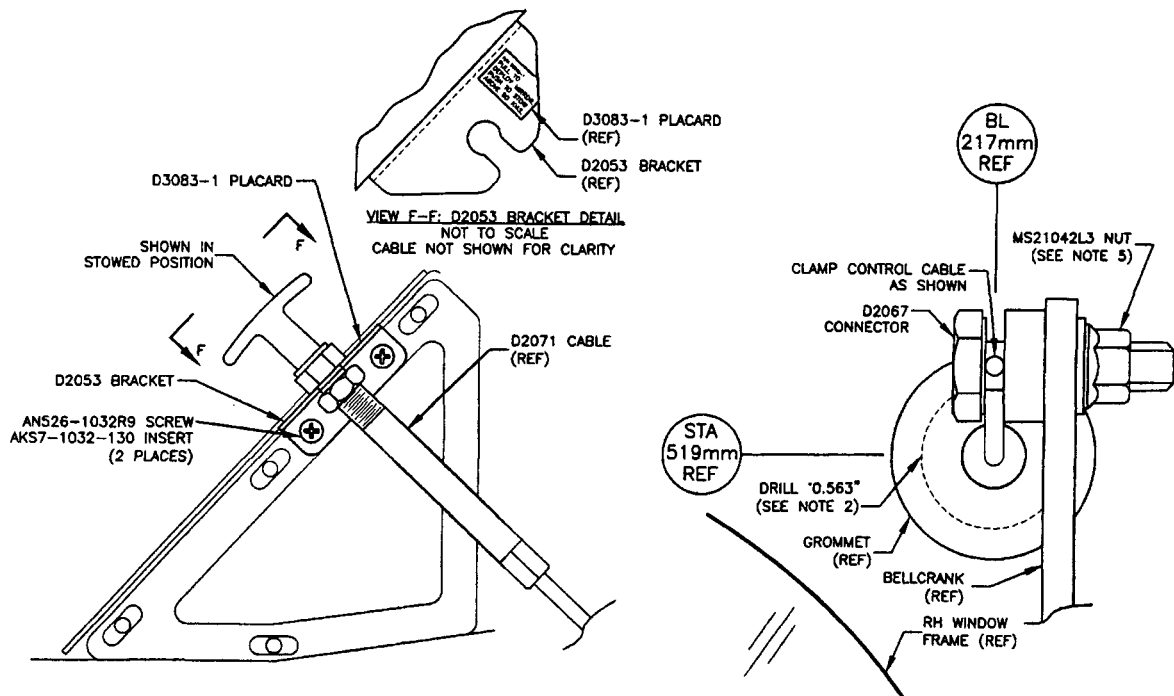
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Figure 25-4 – Detail C: Side View of Mirror Deployment**  
(D119-696-011/-013 Mirror Shown)



**Figure 25-5 – Detail D**  
**Control Panel Attachment**  
(D119-696-011/-013 Mirror Shown)

**Figure 25-6 – Detail E**  
**Bellcrank/Cable Attachment**  
(D119-696-011/-013 Mirror Shown)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries